Work Order ID 105984

August-28-13 11:51:42 AM

D2228

105984

B105984

Item ID: D2228 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Backing Plate

Start Date: 8/28/13 **Start Qty:** 12.00 *12* **Cust Item ID:**

Required Date: 8/28/13 **Req'd Qty:** 12.00 *12* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** ML5 **Date:** 13-08-29 **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D2228 / Rev B									
100	FLOW WATER JET	0.00				24	0		Ae 13.11.18
100									
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2228 Dwg Rev: B Prog Rev: B 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				24	0		Ae 13.11.18
110									
QC	**Memo**	0.00							
Quality Control									
		DAS 27 9-89							
120	QC8- Inspect parts - second check	0.00				24			
120									
QC	**Memo**	0.00 13/11/18							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 105984 *105984*

August-28-13 11:51:42 AM

Item ID: D2228 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Backing Plate **Stop** *NS2*

Start Date: 8/28/13 **Start Qty:** 12.00 *12* **Cust Item ID:**

Required Date: 8/28/13 **Req'd Qty:** 12.00 *12* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1	0.00				24	HG 13-11-18.		
	Memo	0.00							
140 *140* Powdercoat Powder Coating	White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum M126829	0.00				24	ϕ 13-11-20.		DAS 34 9-89
	Memo START TIME: 7:30 OVEN TEMPERATURE: 300 FINISH TIME: 5:00	0.00							
150 *150* QC Quality Control	QC3- Inspect Part Finish	0.00				24			
	Memo	0.00 DAS 27 9-89 13/11/20				cam			

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

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- ☐ Maintenance
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- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
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- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
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- ☐ Temperature/Cure
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- ☐ Other

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Item ID: D2228 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Backing Plate
Start Date: 8/28/13 **Start Qty:** 12.00 *12* **Cust Item ID:**
Required Date: 8/28/13 **Req'd Qty:** 12.00 *12* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: ST007	0.00							
160						24K			DAS 26 9-89
Packaging	**Memo**	0.00							
Packaging									13-11-20
170	QC21- Final Inspection - Work Order Release	0.00							
170						RM 13/11/20			
QC	**Memo**	0.00							
Quality Control									

13-11-20

DQA: _____ Date: _____

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

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- Scrap ☐
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- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
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Process	☐									
Supplier	☐									
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- ☐ Instructions Incomplete/Unclear
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- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Picklist Print

August-28-13 11:51:42 AM

Work Order ID: **105984**

Parent Item: **D2228**

Parent Item Name: Backing Plate

Start Date: 8/28/13 **Required Date:** 8/28/13

Start Qty: 12.00 **Required Qty:** 12.00

Comments: IPP: B00.08.22Re-formatEC
IPP C 07.03.20 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063 5052-H32 .063 Sheet		Purchased	No			100	sf	129.5653	**0.0227**	~~0.2724~~	Ac	13.11.18	

Location	Loc Qty	Loc Code
MAT022	129.565264	
114322	25.705264	
120603	18.5	
121901	19.34	
125272	66.02	125272 → .54

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WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____

Part No. _____

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AGAINST DEPARTMENT/PROCESS

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Supplier	☐									
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- ☐ Temperature/Cure
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- ☐ Wrong Stock Pulled
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_____

_____

_____

DART AEROSPACE LTD	Work Order:	105984
Description: Backing Plate	Part Number:	D2228
Inspection Dwg: D2228 **Rev:** B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.001	.171	-		V	JKm-01
1.920	+/-0.010	1.920	-		V	
1.620	+/-0.010	1.620	-		V	
0.300	+/-0.010	.300	-		V	
0.300	+/-0.010	.300	-		V	
1.410	+/-0.010	1.410	-		V	
1.710	+/-0.010	1.710	-		V	
0.063	+/-0.010	.064	-		V	

Measured by:		Audited by:	DAS 27 9-89	Prototype Approval:	N/A
Date:	13.11.18	Date:	13-11-18	Date:	N/A

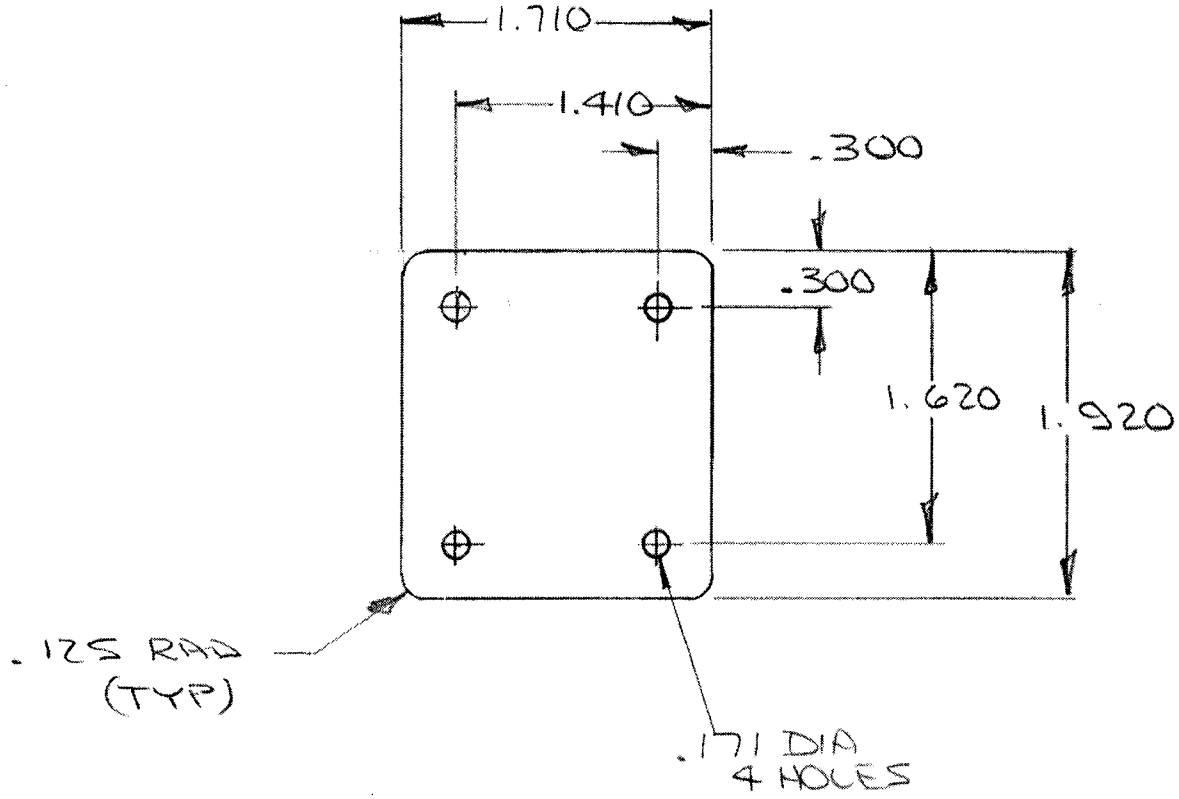
Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ	

DRAWN: BRADLEY 94.2.23		**DART AERO ACCESSORIES INC** VICTORIA INTERNATIONAL AIRPORT, CANADA
DESIGN: BRADLEY 94.2.23		DRAWING NO. D2228 REV. B SHEET 1 OF 1
STRESS		TITLE: BACKING PLATE
B	00.09.11	UPDATE FINISH SPEC. AP

DART

QA COPY ISSUED

RELEASED
00.09.12



MATERIAL: 5052-H32 (QQ-A-250/8) .063 THICK

FINISH: ⚠B CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3

105984 MCT
13-08-29

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